

Work Order ID 70789

Wednesday, June 15, 2011 10:55:52 AM



Page 1

Item ID: D2344	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Litter Deck Plate, 350					
Start Date: 6/15/2011	Start Qty: 6.00		Cust Item ID:		
Required Date: 6/15/2011	Req'd Qty: 6.00		Customer:		
Reference:					
Approvals: Process Plan:	Date: 11-06-15	Tooling:		Date:	
QC:	Date:	SPC (Y/N):		Date:	
			Run	Start	
				Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2344	Rev F								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
2074 .063									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

B11-6-22

9

B11-6-22

8 w/6/22

79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Wednesday, June 15, 2011 10:55:52 AM



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Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 6/15/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/15/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges □2-Countersink holes per Dwg D2344

EP 4/06/22 (8) Pto →

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8 u/06/23

(X8) (8)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

8x Ø m-11/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2344 PAR #: _____ Fault Category: Small F&B NCR: Yes No DQA: _____ Date: _____

Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>70729</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/23</u>	<u>130</u>	<u>1 part 1 hole count sink is too deep RC process back of A/H test</u>	<u>11.06.23</u> <u>GS1042</u> <u>4.1.6</u>	<u>Scrap & destroy</u> <u>2H x 1</u>	<u>SB</u> <u>11/06/23</u>	<u>8</u> <u>11/6/23</u>	<u>11.06.23</u>	<u>8</u> <u>11/6/27</u>

NOTE: Date & initial all entries

Work Order ID 70789



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Wednesday, June 15, 2011 10:55:52 AM

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 6/15/2011

Start Qty: 6.00



Cust Item ID:

Required Date: 6/15/2011

Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per.QSI005 4.3

0.00

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

3200.2

2-30

8x 8 m-11/06/27

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8 8 11/06/28

180



Packaging

Packaging

Identify as per dwg & Stock Location: 51224

0.00

Memo

0.00

CL 11/06/28 (8)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date:	6/15/2011	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

11/6/28
MF
11-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 10:56:05 AM

Page 1

Work Order ID: 70789

Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350



Start Date: 6/15/2011

Required Date: 6/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: D 00.06.26 ☐ Removed P/O for powder coat ☐ EC ☐
IPP Rev: E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	269.5700	0.745	4.705263	71		
2024-T3 .063 sheet											131-6-22		

Location

Loc Qty

Loc Code

MAT022

269.57

113867

0.19

117018

26.88

117392

242.5

117392

9

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	76789
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.228	✓		V Boz	
5.598	+/-0.010	5.606	✓		V	
4.869	+/-0.010	4.869	✓		V	
3.889	+/-0.010	3.888	✓		V	
3.096	+/-0.010	3.096	✓		V	
2.891	+/-0.010	2.893	✓		V	
16.973	+/-0.010	16.973	✓		V	
0.450	+/-0.010	.449	✓		V	
4.423	+/-0.010	4.422	✓		V	
4.723	+/-0.010	4.724	✓		V	
1.202	+/-0.010	1.200	✓		V	
5.869	+/-0.010	5.870	✓		V	
4.654	+/-0.010	4.652	✓		V	
Ø0.656	+0.005/-0.000	.657	✓		V	
1.888	+/-0.010	1.885	✓		V	
2.285	+/-0.010	2.283	✓		V	
2.683	+/-0.010	2.683	✓		V	
Ø0.171	+0.005/-0.000	.172	✓		V	
3.491	+/-0.010	3.491	✓		V	
Ø0.191	+0.005/-0.000	.192	✓		V	
3.123	+/-0.010	3.125	✓		V	
1.975	+/-0.010	1.973	✓		V	
Ø0.128	+0.005/-0.001	.129	✓		V	

Measured by: RB	Audited by: J	Prototype Approval:	N/A
Date: 11-6-22	Date: 11/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
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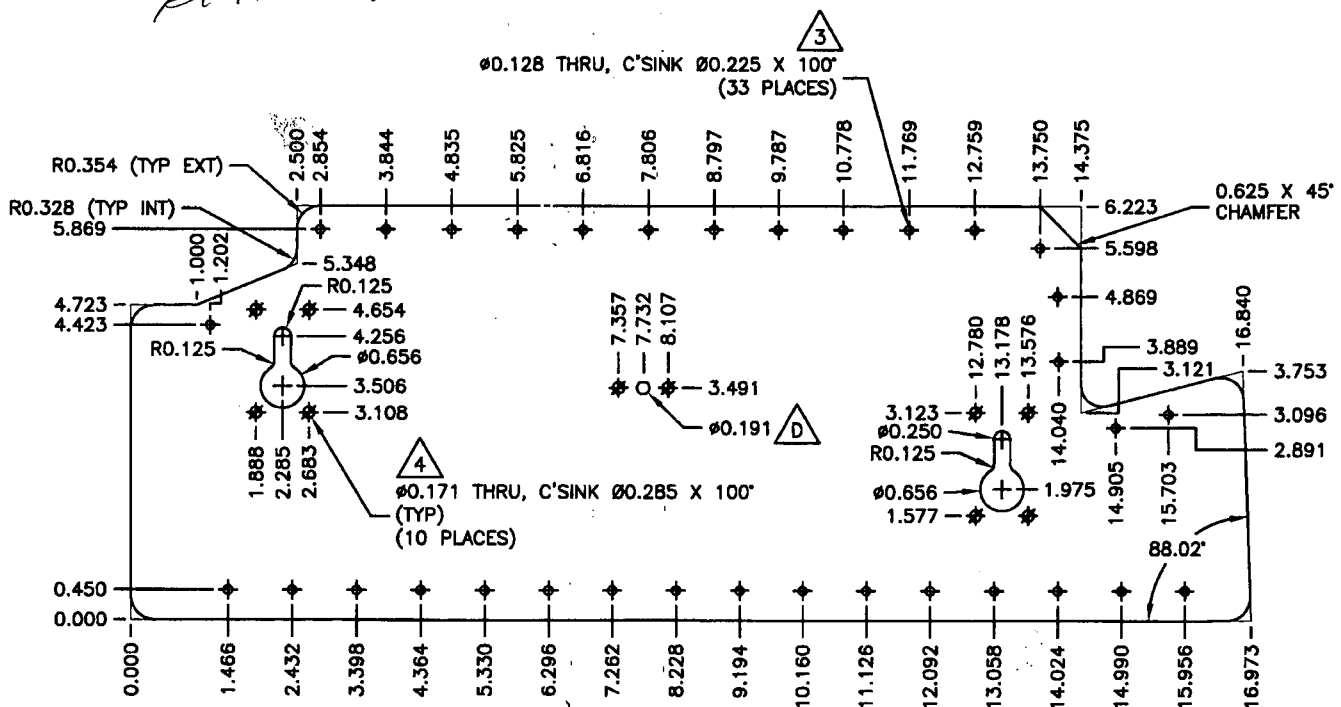
NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>AB</i>	APPROVED <i>HT</i>	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER DECK PLATE, 350		SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70789

pl 11-06-15

**D2344 LITTER DECK PLATE, 350**

- E** 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4
(REF. DART SPEC. M2024T3S)
- F** 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED \star TO Ø0.225 X 100°
- 4) COUNTERSINK HOLES MARKED \star TO Ø0.285 X 100°
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

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